



Dart Aerospace Ltd.
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D3264-1**Job Sheet 191421****Part No:** D3264-1**Job Qty:** 7 pcs**Part Name:** Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/28/19**Job Tracking No:****Due Date:** 3/25/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV A IPP A 04.09.02 New issue KJ/JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	7 pcs	3/25/19	3/25/19	0.00	0.99	Bandsaw - 1		DAS 52-89	19/04/18
110	HAAS 4 Axis - B4B	7 pcs	3/25/19	3/25/19	0.26	7.78	HAAS - 1 - B4B		DAS 52-89	19/04/18
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
120	QC 2	7 pcs	3/25/19	3/25/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51		DAS 52-89	19/04/18
							QC 2 - 52			
							QC 2 - 54			
							QC 2 - 56			

**Container No:** S173506**Part:** D3264-1**Job No:** 191421**Serial No/Batch:** S173506**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 04/18/19

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130 QC 8	7 pcs	3/25/19	0.00 0.00	QC 2 - 57					
				QC 2 - 62					
				QC 2 - 63					
				QC 2 - 8					
				QC 2 - 66					
				QC 2 - 64					
				QC 8 - 12					
				QC 8 - 14					
				QC 8 - 17					
				QC 8 - 20					
				QC 8 - 25					
				QC 8 - 3					
				QC 8 - 32					
				QC 8 - 33					
				QC 8 - 35					
				QC 8 - 39					
				QC 8 - 4					
				QC 8 - 44					
				QC 8 - 45					
				QC 8 - 49					
				QC 8 - 58					
				QC 8 - 8					
				QC 8 - 9					
				QC 8 - 68					
				QC 8 - 67					
				QC 8 - 47					
				QC 8 - 40					
140 Handfinish - 1-1 Chemical-B4B	7 pcs	3/25/19	0.00 0.33	Handfinish - 1 - 1 - B4B					
				Handfinish - 1 - 2 - B4B					
				Handfinish - 1 - 3 - B4B					
				Handfinish - 1 - 4 - B4B					
				Handfinish - 1 - 5 - B4B					
				Handfinish - 1 - 6 - B4B					
				Handfinish - 1 - 7 - B4B					
				Handfinish - 1 - 8 - B4B					
				Handfinish - 1 - 9 - B4B					
				Handfinish - 1 - 10 - B4B					
				Handfinish - 1 - 11 - B4B					
				Handfinish - 1 - 12 - B4B					
				Handfinish - 1 - 13 - B4B					
				Handfinish - 1 - 14 - B4B					
				Handfinish - 1 - 15 - B4B					
				Handfinish - 1 - 16 - B4B					
				Handfinish - 1 - 17 - B4B					
				Handfinish - 1 - 18 - B4B					
				Handfinish - 1 - 19 - B4B					
				Handfinish - 1 - 20 - B4B					
				Handfinish - 1 - 21 - B4B					
				Handfinish - 1 - 22 -					

				B4B	
150 Powdercoat - 1 White GI(A)- B4B	7 pcs	3/25/19	0.00 0.30	Powdercoat - 1 - B4B	M 19-4-22
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	7 pcs	3/25/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
170 Packaging 3-1 - Stock - B4B	7 pcs	3/25/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS 40 9-89
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS 28 9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

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180 QC 21 - SA

7
pcs

3/25/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - (Bandsaw) CUT BLANK 5.700" LONG

Descriptions: 110 - (HAAS CNC Vertical Machine) MACHINE AS PER FOILIO FA447 DWG REV: A

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X4.500	6061-T6 Bar 1.25 X 4.50	3.3460 ft (.478 ea)	100-Bandsaw - 1	S131197

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X4.500	3	12	0

Part Specifications

Specifications could not be found.

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MAT
used
3.350'

DART AEROSPACE LTD		Work Order:	191421
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.687	✓		Vern.	
0.063	+/-0.010	0.065	✓		Vern.	
0.125	+/-0.010	0.130	✓		Vern.	
0.875	+0.010/-0.020	0.882	✓		Vern.	
0.062	+/-0.010	0.060	✓		Micro.M.	
R0.03	+/-0.030	0.030	✓		R. Gage	
R0.13	+/-0.030	0.125	✓		R. Gage	
1.00	+/-0.030	1.013	✓		Vern.	
0.125	+/-0.010	0.124	✓		Vern.	
0.600	+/-0.010	0.598	✓		Vern.	
4.000	+/-0.005	4.000	✓		Vern.	
0.750	+/-0.010	0.750	✓		Vern.	
Ø0.194	+0.005/-0.000	0.194	✓		G. Pins.	
5.50	+/-0.030	5.500	✓		Vern.	
0.125	+/-0.010	0.125	✓		Vern.	
0.063	+/-0.010	0.065	✓		Vern.	
R0.25	+/-0.030	0.250	✓		R. Gage	
4.27	+/-0.030	4.268	✓		Vern.	
R0.30	+/-0.030	0.300	✓		R. Gage	

Measured by: DIPK	Audited by: JNL	Prototype Approval:	N/A
Date: 19-04-17	Date: 19/04/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					